

Work Order ID 128435

Friday, January 16, 2015 2:37:11 PM

128435

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Item ID: D3684-049 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Leg Assembly
 Start Date: 1/16/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1501-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3684	E								

100 Pick Kit 0.00
100 /X DAS 28 FEB 11 2015
 Packaging Memo 0.00
 Packaging

110 Small Fab 0.00
110 /X DAS 28 FEB 11 2015
 Small Fab Memo 0.00
 Small Fab 1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684 m128063
 2-Assemble as per Dwg D3684

120 QC5- Inspect part completeness to step on W/O 0.00
120 D 38 9-89
 QC Memo 0.00
 Quality Control

FEB 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D3684-049

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Leg Assembly

Start Date: 1/16/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/16/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location

St 231

0.00

130

Packaging

Memo

0.00

Packaging

FEB 12 2015

~~046~~
~~27~~
~~0-00~~

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS 15-02-13AS.212

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Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 128435

128435

Parent Item: D3684-049

D3684-049

Parent Item Name: Aft Leg Assembly

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified
 By:DD IPP REV:D
 13.01.24 PER ECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-3		Manufactured	No			110	Each	11.0000	1	1			
D3688-3									**			DAS	FEB 11 2015
Stud												28	
												9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				GA				11					
				100388				4					
				101630				4					
				105607				3					
D3689-1		Manufactured	No			110	Each	22.0000	1	1			
D3689-1									**			DAS	
Sleeve												28	
												9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				FG				2					
				83358				2					
				st510				20					
				105605				20					
D3691-041		Manufactured	No			110	Each	12.0000	1	1			
D3691-041									**			DAS	
Stud Assembly												28	
												9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				GA				12					
				122589				5					
				125211				7					

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Picklist Print

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Parent Item: D3684-049

D3684-049

Parent Item Name: Aft Leg Assembly

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 1.00

Required Qty: 1.00

NAS509L12C

Purchased

No

110

Each

78.0000

1

1

NAS509L12C

Nuts

**DAS
28
9-89**

FEB 11 2015

Location

Loc Qty

Loc Code

ST260a

77

m128578

77

ST265

1

120498

1

NAS509-12C

Purchased

No

110

Each

47.0000

1

1

NAS509-12C

Nuts

**DAS
28
9-89**

Location

Loc Qty

Loc Code

ST261

47

121162

1

m128199

10

m128429

9

m128578

27

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